

Work Order ID 85615

85615

Page 1

June-12-12 8:50:15 AM

Item ID: D4095-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate Assembly

Stop ***NS2***

Start Date: 12/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling: 1

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4095

B

(10)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B/L-6-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B/L-6-13

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sc7/06/15

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85615

85615

Page 2

June-12-12 8:50:15 AM

Item ID: D4095-043
Revision ID:
Item Name: Wearplate Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 12/06/2012 Start Qty: 10.00 ***10***
Required Date: 26/06/2012 Req'd Qty: 10.00 ***10***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1- bend section C-C first
2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

0.00

0.00

(11)

SB 12/06/19

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D4095

0.00

0.00

8/17/06/19

(11)

150

150

Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: M122030 0.00
Large Fab

Memo

0.00

(X 11)

MAL

12/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85615***85615***

Page 3

Item ID: D4095-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 12/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

8/7/06/27

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

8/7/06/27

Quality Control

(H)

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 122212

12-6-30 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85615

June-12-12 8:50:15 AM

85615

Page 4

Item ID: D4095-043
 Revision ID:
 Item Name: Wearplate Assembly
 Start Date: 12/06/2012 Start Qty: 10.00
 Required Date: 26/06/2012 Req'd Qty: 10.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00				11x	4	11/12/07/03	
Quality Control									
200	Identify as per dwg & Stock Location: <u>FR-1</u>	0.00							
200									
Packaging	Memo	0.00				11x	4	11/12/07/03	
Packaging						counted			
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/7/4 *[Signature]*

ME
 12/07/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 8:50:18 AM

Page 1

Work Order ID: 85615

85615

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	38.5624	2.275	23.94737			

M304S16GA

304/316 Sheet .063

**

1312-6-13

Location

Loc Qty

Loc Code

MAT020

38.562433

121626

3.1778

121889

35.384633

121626 x 5 = 10
121889 x 5 = 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	85615
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190	2		✓ R62	
0.300	+/-0.010	0.300	2		✓	
0.300	+/-0.010	0.304	2		✓	
2.432	+/-0.010	2.440	2		✓	
3.227	+/-0.010	3.223	2		✓	
4.06	+/-0.030	4.050	2		✓	
2.50	+/-0.030	2.50	2		✓	
4.98	+/-0.030	4.980	2		✓	
8.43	+/-0.030	8.420	2		T R62	
11.50	+/-0.030	11.50	2		T	
21.750	+/-0.010	21.750	1		T	
3.500	+/-0.010	3.501	2		T	
12.22	+/-0.030	12.22	2		T	
6.000	+/-0.010	6.000	1		T	
12.100	+/-0.010	12.100	2		T	
21.00	+/-0.030	21.00	2		T	
30.000	+/-0.010	30.000	2		T	
36.000	+/-0.010	36.000	2		T	
38.88	+/-0.030	38.88	1		T	
0.063	+/-0.010	0.059	2		✓	

Measured by: R	Audited by: J	Preliminary Approval:
Date: 12-6-13	Date: 12/09/15	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

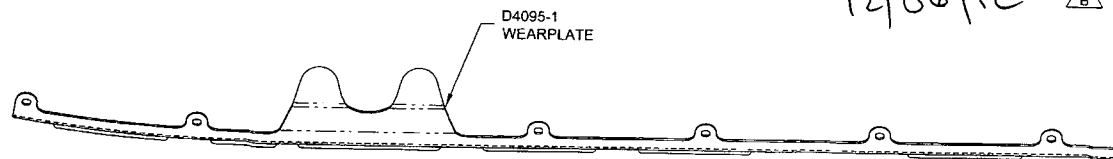
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

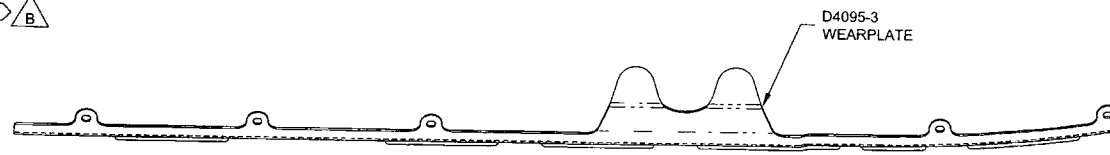
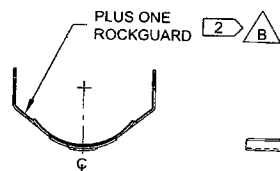
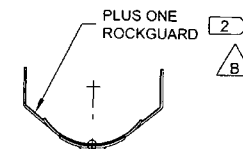
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. PS615 MJS
12/06/12

ITEM	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



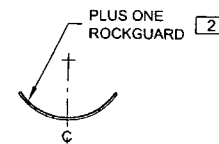
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F: 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV	DESIGN	DATE	
DRAWN	XDF	DATE	
CHECKED	NO	DRAWING NO	REV. B
MFG. APPR.	NO	D4095	SHEET 1 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	WEARPLATE	NTS
DATE	11.10.18		

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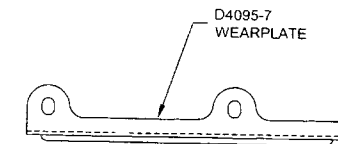
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

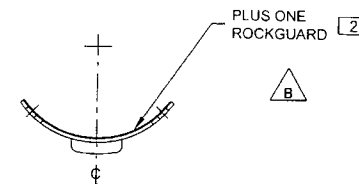
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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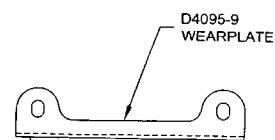
NOTE: Date & initial all entries



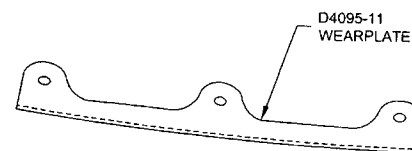
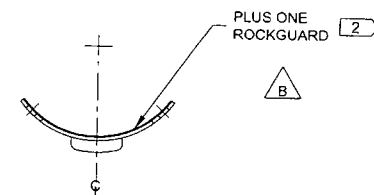
D4095-047 WEAR PAD ASSEMBLY



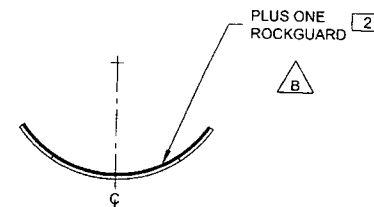
Handwritten signature/initials



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



RELEASED
2011-10-31
Handwritten initials

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>Handwritten initials</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>Handwritten initials</i>	D4095	SHEET 2 OF 8
APPROVED	<i>Handwritten initials</i>	TITLE	SCALE
DE APPR.	<i>Handwritten initials</i>	WEARPLATE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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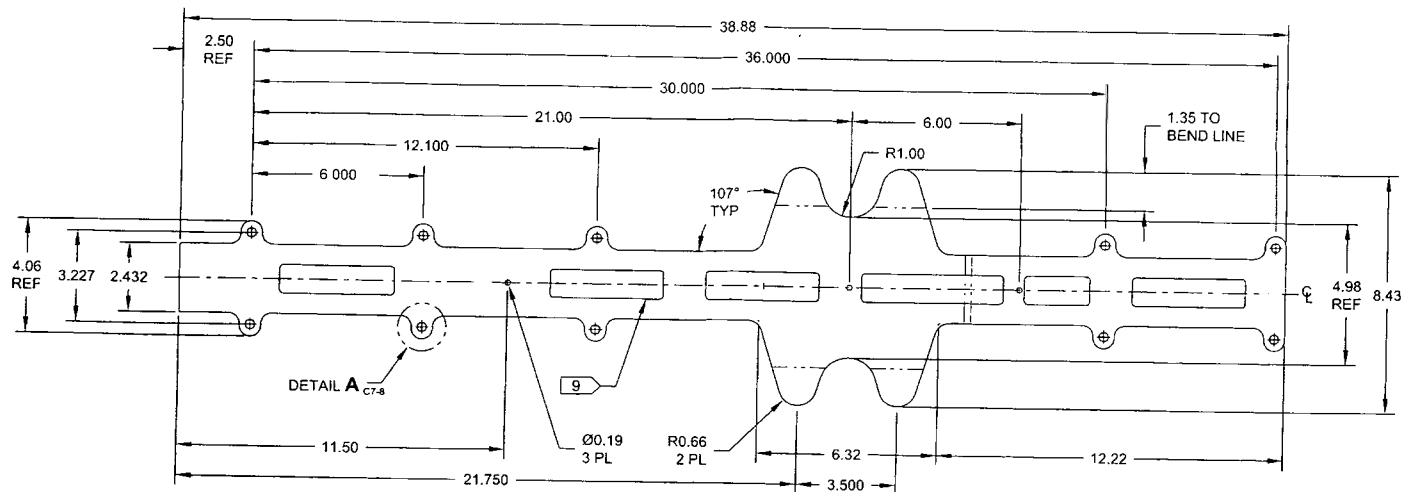
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

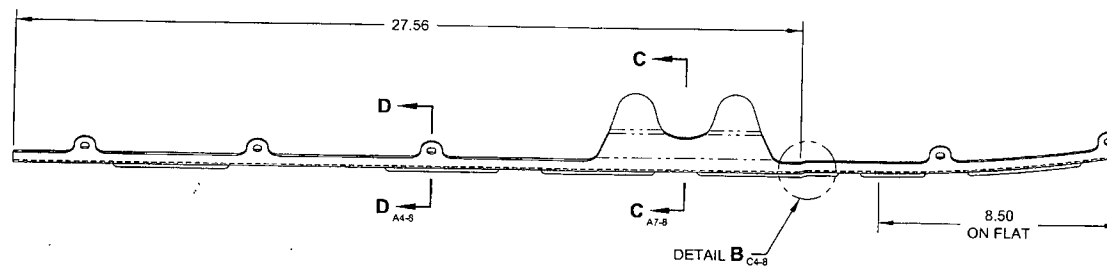
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG APPR.	10	D4095	SHEET 4 OF 8
APPROVED	10	TITLE	SCALE
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RELEASE
2011-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

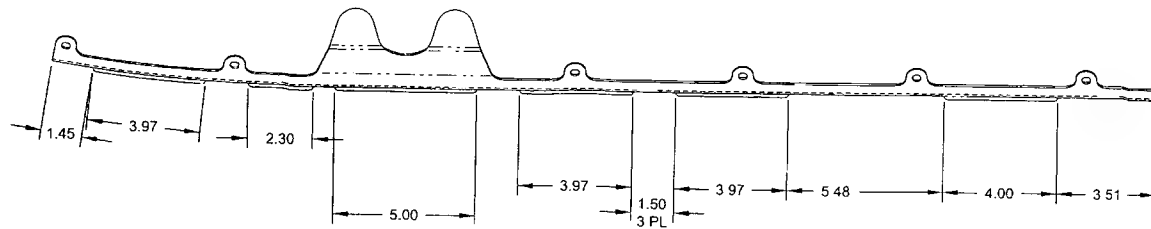
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

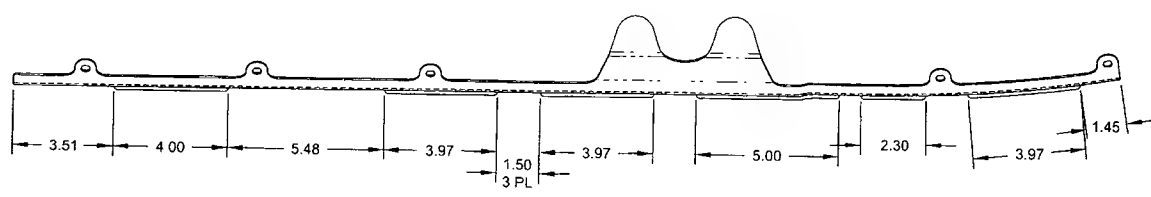
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25615



D4095-1 WELDING DETAIL 



D4095-3 WELDING DETAIL 

RELEASED
2011-10-31
MR

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>10</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>10</i>	D4095	SHEET 5 OF 8
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	WEARPLATE	NTS
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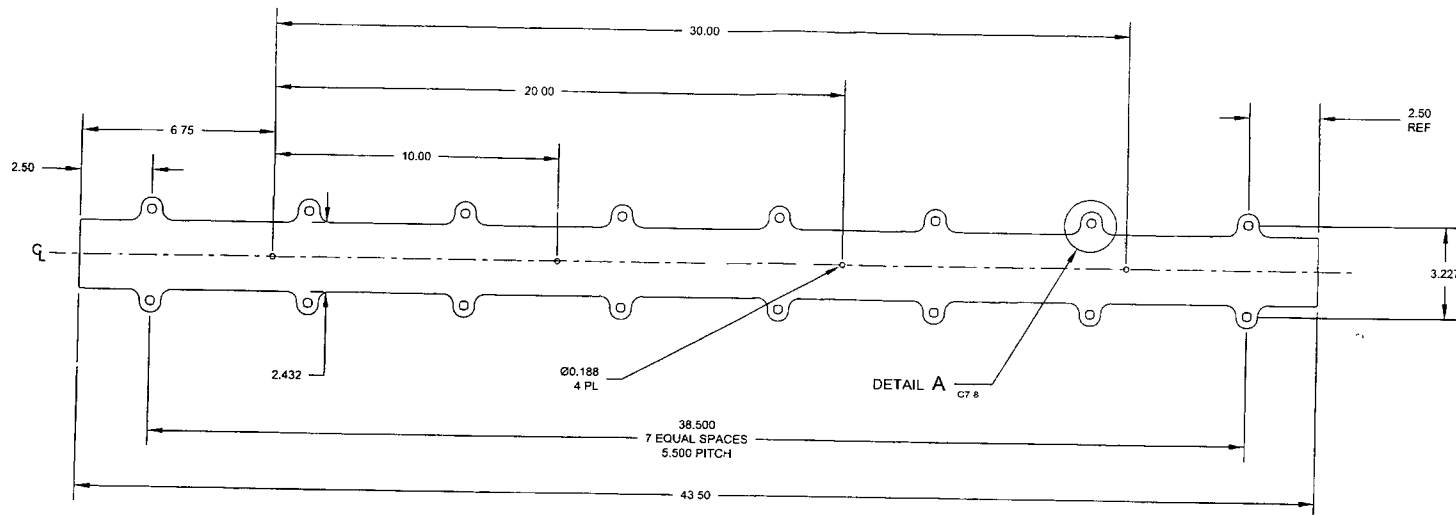
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

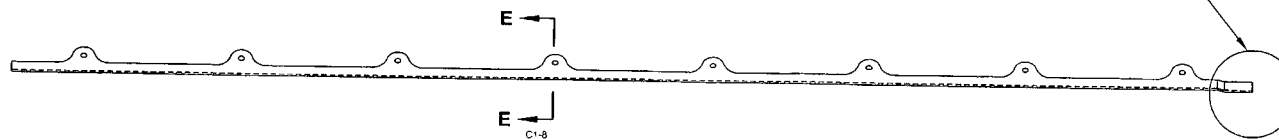
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4095-5F FLAT PATTERN



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

RELEASED
2011-10-31
ND

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 6 OF 8
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DE APPR.	10	WEARPLATE	NTS
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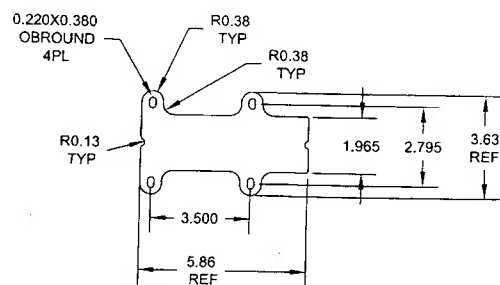
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

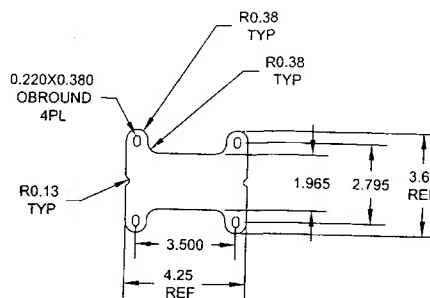
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

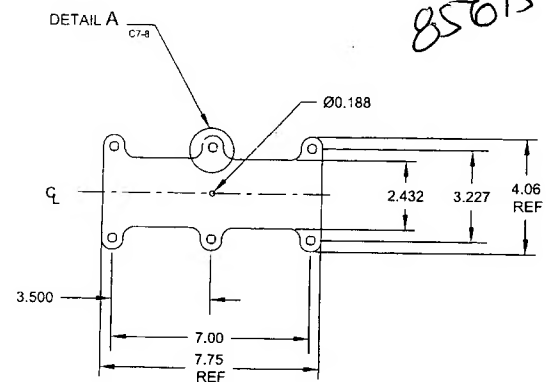
NOTE: Date & initial all entries



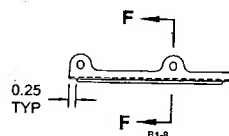
D4095-7F FLAT PATTERN



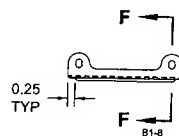
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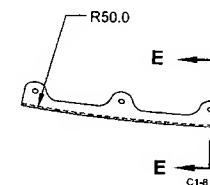
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 7 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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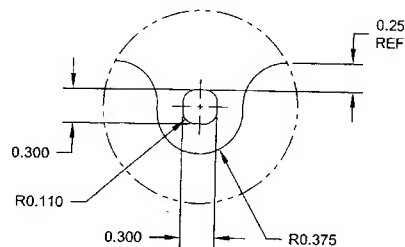
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

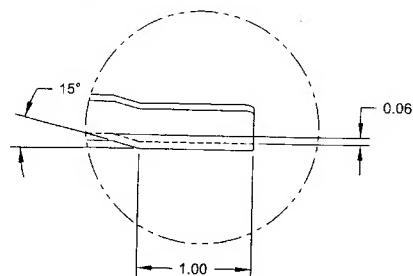
NOTE: Date & initial all entries



DETAIL A: TAB DETAIL

SCALE 4X

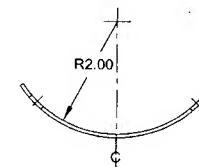
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

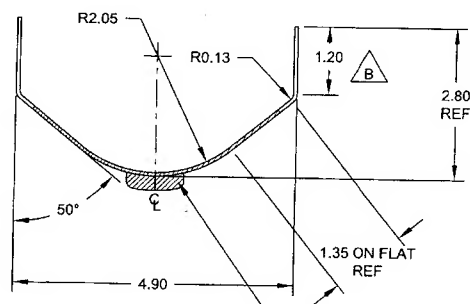
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

RELEASED
2011-10-31
MPD

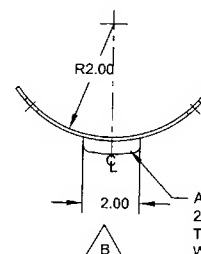


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

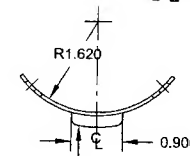


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

DESIGN		DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B
MFG. APPR.	<i>[Signature]</i>	D4095 SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE NTS
DATE	11.10.18	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries